

Work Order ID 72959

Monday, August 22, 2011 10:41:03 AM



Page 1

Item ID: K642-511

Accept



Setup Start



Revision ID:

Item Name: saddle kit 642-511

Stop



Start Date: 8/22/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 8/26/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan: MF

Date: 11-08-22

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

DSI 9467

Rev A

IIN D206-642

Rev N

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Create White labels per PPP K642-511

CHG004

8 11/08/23

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/8/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72959

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Page 2

Item ID: K642-511

Accept



Setup Start



Revision ID:

Stop



Item Name: saddle kit 642-511

Start Date: 8/22/2011 Start Qty: 3.00



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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00

5 w/08/23



130



Packaging

Packaging

Packaging

Memo

0.00

0.00

Identify and pack for shipping as per PPP K642-511 Location:

Rec B

PK

11/8/23 SP 30

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/8/24

MF 11-08-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Page 1

Work Order ID: 72959

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 8/22/2011


Required Date: 8/26/2011

Start Qty: 3.00


Required Qty: 3.00

Comments: IPP Rev:A 07.06.05 new issue EC
IPP Rev.B 08.02.05, Per ECN1080P LL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3C35A		Purchased	No			110	Each	75.0000	3	9			
													
BOLT													

Location	Loc Qty	Loc Code
FG	4	
18914	4	
ST352	20	
117366	20	
ST353	51	
114523	6	
117872	25	
118628	20	

AN3C36A		Purchased	No			110	Each	113.0000	9	27			
													
BOLT													

Location	Loc Qty	Loc Code
FG	14	
101261	4	
116590	10	
FP-B	17	
111925	17	
ST353	82	
109771	12	
118191	50	
118451	20	

W/O:		WORK ORDER CHANGES					
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Page 2

Work Order ID: 72959

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 8/22/2011

Required Date: 8/26/2011

Start Qty: 3.00

Required Qty: 3.00

AN3C41A

Purchased

No

110

Each

97.0000

8

24



BOLT

Location

Loc Qty

Loc Code

FG

4

103324

4

ST354

93

117950

43

118518

50

AN4C6A

Purchased

No

110

Each

385.0000

12

36



Bolt

Location

Loc Qty

Loc Code

FG

4

103344

4

ST356

381

116704

15

117872

66

118191

100

118451

200

AN5C11A

Purchased

No

110

Each

118.0000

8

24



Bolt

Location

Loc Qty

Loc Code

FG

4

104817

4

ST337

60

117872

60

ST338

54

117094

4

118191

50

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Page 3

Work Order ID: 72959

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 8/22/2011

Required Date: 8/26/2011

Start Qty: 3.00

Required Qty: 3.00

AN5C12A

Purchased

No

110

Each

79.0000

4



BOLT

Location

Loc Qty

Loc Code

FG

2

18918

2

ST338

77

117313

27

118451

50



12

11/8/23

AN5C13A

Purchased

No

110

Each

96.0000

4



BOLT

Location

Loc Qty

Loc Code

FG

4

18918

4

ST338

92

117313

42

117872

50



12

AN5C15A

Purchased

No

110

Each

98.0000

1



Bolt

Location

Loc Qty

Loc Code

ST338

23

118191

23

ST339

75

117885

25

118267

50



3

11/8/23 (30)

3

Picklist Print

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Page 4

Work Order ID: 72959

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 8/22/2011

Required Date: 8/26/2011

Start Qty: 3.00

Required Qty: 3.00

AN5C32A

Purchased

No

110

Each

97.0000

2

6



Location

Loc Qty

Loc Code

FG

4

18918

4

ST340

93

116380

43

117407

25

117969

25

AN5C34A

Purchased

No

110

Each

52.0000

2

6



Location

Loc Qty

Loc Code

FG

2

18918

2

ST340

50

117763

25

117950

25

AN5C35A

Purchased

No

110

Each

64.0000

1

3



Location

Loc Qty

Loc Code

ST340

39

108407

39

ST341

25

118451

25

AN960C10L

NAS1149C0332
R

Purchased

No

110

Each

0.0000

24

72



washer

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Work Order ID: 72959

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 8/22/2011

Required Date: 8/26/2011

Start Qty: 3.00

Required Qty: 3.00

AN960C416L Purchased No

110 Each 0.0000

24 72 27x

(43V)

WASHER

AN960C516L NAS1149C0532 Purchased No

110 Each 0.0000

8 24 4x

WASHER

D206-648-013 CH16002 Manufactured No

110 Each 3.0000

1 8 2x

GHW Modification

Location

Loc Qty

Loc Code

FG120

3

71577

1

71578

2

D2652 Manufactured No

110 Each 367.0000

16 48

Bushing

Location

Loc Qty

Loc Code

FG

44

31985

44

ST

201

53741

0

72120

201

ST019

122

71833

122

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Work Order ID: 72959

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 8/22/2011

Required Date: 8/26/2011

Start Qty: 3.00

Required Qty: 3.00

D2712

Manufactured No

110

Each

561.0000

10

30



Set Screw

Location

Loc Qty

Loc Code

FG 50

29962 50

ST021 511

71160 211

72231 300

D2932-1

Manufactured No

110

Each

8.0000

1

3



Saddle LH Out, 206

Location

Loc Qty

Loc Code

ST428 8

69922 4

70874 4

D2933-1

Manufactured No

110

Each

7.0000

1

3



Saddle LH In, 206

Location

Loc Qty

Loc Code

ST421 1

71062 1

ST428 6

69926 2

70875 4

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Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Work Order ID: 72959

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 8/22/2011

Required Date: 8/26/2011

Start Qty: 3.00

Required Qty: 3.00

D2934

Manufactured No

110

Each

39.0000

2



Saddle Spacer



6
8

Location

Loc Qty

Loc Code

FG

6

31929

6

ST027

33

70772

33

D2935

Manufactured No

110

Each

31.0000

2



Saddle Spacer



6
8

Location

Loc Qty

Loc Code

ST027

31

70770

31

D2938-1

Manufactured No

110

Each

7.0000

1



Saddle LH Out, 206



6
3

Location

Loc Qty

Loc Code

ST428A

7

69918

1

70862

6

D2939-1

Manufactured No

110

Each

4.0000

1



Saddle LH In, 206



1
2
3
11/8/22
30

Location

Loc Qty

Loc Code

ST421

1

71056

1

ST428A

3

69927

3

3

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Page 7

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 72959

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 8/22/2011

Required Date: 8/26/2011

Start Qty: 3.00

Required Qty: 3.00

D3396-3

Manufactured No

110

Each

21.0000

2

6



Spacer

Location

Loc Qty

Loc Code

FG

10

26772

10

ST052

11

70983

11

D3407-043

Manufactured No

110

Each

12.0000

1

3



Tow Ring

Location

Loc Qty

Loc Code

ST463

10

70982

9

72513

1

ST464

2

68339

2

D3456-1

Manufactured No

110

Each

58.0000

1

3



Washer

Location

Loc Qty

Loc Code

FG

7

25701

7

ST054

51

66848

3

71165

48

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Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____ .

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 72959

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 8/22/2011

Required Date: 8/26/2011

Start Qty: 3.00

Required Qty: 3.00

D3457-1

Manufactured No

110

Each

62.0000

2

6



Washer

Location

Loc Qty

Loc Code

FG

10

32409

10

ST054

52

67779

1

71849

51

D3672-1

Manufactured No

110

Each

1,260.000

24

72



Phenolic Washer

Location

Loc Qty

Loc Code

ST074

1258

64177

262

66821

496

72229

500

ST077

2

52505

2

D3672-3

Manufactured No

110

Each

839.0000

24

73



Phenolic Washer

Location

Loc Qty

Loc Code

ST074

839

64176

225

71159

114

72230

500

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Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 72959

Parent Item: K642-511

Parent Item Name: saddle kit 642-511*

Start Date: 8/22/2011

Required Date: 8/26/2011

Start Qty: 3.00

Required Qty: 3.00

D3672-7

Manufactured No

110

Each

486.0000

24

72



Phenolic Washer

Location

Loc Qty

Loc Code

ST074

486

53237

244

64175

242

72

MS21043-3

Purchased No

110

Each

998.0000

20

60



Nut

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

926

112314

6

118077

420

118614

500

60

MS21043-4

Purchased No

110

Each

939.0000

13



Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

899

117793

482

118378

417

39

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 72959

Parent Item: K642-511

Parent Item Name: saddle kit 642-511



Start Date: 8/22/2011

Required Date: 8/26/2011

Start Qty: 3.00

Required Qty: 3.00

MS21043-5

Purchased

No

110

Each

516.0000

4

12



Nut



11/8/22 sl (3)

Location

Loc Qty

Loc Code

FG

20

101418

20

ST301

396

112314

296

116548

100

ST314

100

118159

100

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DART AEROSPACE USA, INC.

D206-642

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4.7 206L/L-1/L-3/L-4/407 HIGH GEAR FLOAT SKIDTUBES (TRI-BAG COMPATIBLE)

Item	Qty -511	Qty -512	Qty -541	Qty -547	Qty -013	Part Number	Description
	X					D206-642-511	SKIDTUBE INSTALLATION, LH
		X				D206-642-512	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-541	SKIDTUBE
				X		D206-642-547	WEARSHOE KIT (REPLACES -543 KIT)
	1	1			X	D206-648-013	GROUND HANDLING KIT
1			1			D3274-041	SKIDTUBE ASSEMBLY
3			1			D2646	* AFT CAP ⁽¹⁾
4			2			AN3C4A	* BOLT ⁽¹⁾
5A			2			AN960C10L	* WASHER ⁽¹⁾
5B			2			D3672-1	* WASHER (REPLACES NAS1515H3L) ⁽¹⁾
6	1					D2932-1	SADDLE, FWD OUT, LH
6		1				D2932-2	SADDLE, FWD OUT, RH
7	1					D2933-1	SADDLE, FWD IN, LH
7		1				D2933-2	SADDLE, FWD IN, RH
8	1					D2938-1	SADDLE, AFT OUT, LH
8		1				D2938-2	SADDLE, AFT OUT, RH
9	1					D2939-1	SADDLE, AFT IN, LH
9		1				D2939-2	SADDLE, AFT IN, RH
10	8	8				AN3C41A	BOLT
11	16	16				D2652	BUSHING
12A	8	8				MS21043-3	NUT
12B	16	16				D3672-7	WASHER (REPLACES NAS1515H5)
13	4	4				AN5C11A (or AN5C12A)	* BOLT ⁽²⁾
14	4	4				AN5C11A (or AN5C13A)	* BOLT ⁽²⁾
15A	8	8				AN960C516L	WASHER
15B	8	8				D3672-7	WASHER (REPLACES NAS1515H5L)
16	12	12				AN4C6A	BOLT
17A	24	24				D3672-3	WASHER (REPLACES NAS1515H4L)
17B	24	24				AN960C416L	WASHER
18	12	12				MS21043-4	NUT
20A			9	9		D3537-1	* WEARPAD ⁽¹⁾ (REPLACES D2648-3)
21A			1	1		D3537-3	* WEARPAD ⁽¹⁾ (REPLACES D3429-1)
22A			1	1		D3535-15	* WEARSHOE ⁽¹⁾ (REPLACES D2656-15)
22B			1	1		D3536-15	* GASKET ⁽¹⁾
23A			1	1		D3535-23	* WEARSHOE ⁽¹⁾ (REPLACES D2656-23)
23B			1	1		D3536-23	* GASKET ⁽¹⁾
24A			1	1		D3535-39	* WEARSHOE ⁽¹⁾ (REPLACES D3287-1)
24B			1	1		D3536-39	* GASKET ⁽¹⁾
25A			1	1		D3535-35	* WEARSHOE ⁽¹⁾ (REPLACES D2656-35)
25B			1	1		D3536-35	* GASKET ⁽¹⁾
26A			78	78		AN3C4A	* BOLT ⁽¹⁾
26B			78	78		AN960C10L	* WASHER ⁽¹⁾
26C			78			ALS7-1032-130 (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)	* INSERT ⁽¹⁾
30	1	1				D3407-043	TOW RING
32A	1	1				D3456-1	WASHER
32B	2	2				D3457-1	WASHER
33	1	1				MS21043-4	NUT
34			1			AN4C5A	BOLT
35			1			AN960C416	WASHER
36			1			D3413-1	RING
37	10	10				D2712	SET SCREW
38	2	2				D2934	SADDLE SPACER
39	2	2				D2935	SADDLE SPACER

continued on next page...

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Date: 09.09.09

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ITEM	QTY -511	QTY -512	QTY -541	QTY -547	QTY -013	PART NUMBER	DESCRIPTION
40					2	D3414-041	LUG ASSEMBLY (GHW)
41					4	AN3C37A	BOLT
42					8	D2652	BUSHING
43					4	MS21043-3	NUT
44					4	AN960C10	WASHER
50	9	9				AN3C36A	BOLT
51	3	3				AN3C35A	BOLT
52	24	24				AN960C10L	WASHER
53	24	24				D3672-1	WASHER (REPLACES NAS1515H3L)
54	12	12				MS21043-3	NUT
55	2	2				D3396-3	SPACER
56A	1	1				AN5C35A	BOLT
56B	1	1				AN5C15A	BOLT
60	2	2				AN5C32A	BOLT
61	2	2				AN5C34A	BOLT
62	4	4				MS21043-5	NUT

NOTES: (1) DENOTES THAT PART IS INCLUDED WITH D3274-041 ASSEMBLY ABOVE
(2) CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)